

Garant
Subland drill HSS 90°, vaporised, for threads: M8

Order data

Order number	117060 M8
GTIN	4045197035813
Item class	11C

Description
Version:

Drill and counterbore each with its own chip flutes and guide chamfers. This means the profile of the stepped drill is retained even after repeated regrinding.

Application:

Tapping hole and countersink are produced **in one operation**, precisely aligned.

For drilling tapping holes to DIN 336 sheet 1 with 90° countersinking (similar to DIN 69, medium version).

No. of teeth Z: 2

Through-coolant: no

Ø D₁ 1st step with chamfer h9: 6.8 mm

Ø D₂ 2nd step with chamfer h8: 9 mm

Step height L₁ 1st step: 21 mm

Flute length L_c: 81 mm

Overall length L: 125 mm

Shank Ø D_s: 9 mm

Technical description

Feed f in steel < 750 N/mm ²	0.1 mm/rev.
Flute length L _c	81 mm
for threads	M8
Ø D ₁ 1st step with chamfer h9	6.8 mm
Ø D ₂ 2nd step with chamfer h8	9 mm
Shank Ø D _s	9 mm
Overall length L	125 mm

No. of teeth Z	2
Through-coolant	no
Step height L ₁ 1st step	21 mm
Coating	vaporised
Tool material	HSS
Standard	DIN 8378
Tolerance nominal Ø	h9
Point angle	118 °
Shank	Parallel shank to h8
Helix angle	20-30 °
Countersink angle	90 °
Shank tolerance	h8
Colour ring	without
Application for type of drilling	for blind hole and through hole
Type of product	Stepped drill

User data

	Suitability	V _c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	45 m/min	N
Steel < 500 N/mm ²	suitable	40 m/min	P
Steel < 750 N/mm ²	suitable	30 m/min	P
Steel < 900 N/mm ²	suitable	25 m/min	P
GG(G)	suitable	25 m/min	K
CuZn	suitable only under restricted conditions	80 m/min	N
Oil	suitable		
wet maximum	suitable		

